

Ship Oct. 25

Work Order ID 74933

74933

Page 1

October 13, 2011 1:04:52 PM

Item ID: D135-751-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube Installation

Start Date: 10/13/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/20/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J. Date: 11/10/13 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3492

C

D3507

Rev C

100

0.00

100

DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPP D135-751-011

CHG001

5/10/26

Handwritten signature and date: 11-10-26

B74933

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Skidtubes	0.00							
120									
Skidtubes	Memo	0.00							
Skidtubes	1-Cut Aft end as per dwg D3507								
	2-Deburr ends								
	3-Drill Aft & Fwd Cap holes using DT8678 & DT8901								
	4-Locate DT8870 & Drill Ground wire hole on top of Tube.								
	6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X- Bolt holes using #30" drill.****DO NOT OPEN AFT CAP HOLES*****								
	7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES.								
	8-Open six rear wearplate holes using DT8892.Open holes to 0.297"								
	9-Open Aft & Fwd Cap holes using .208" drill.								
	10-Bore out aft end of tube as per Dwg D3507 & Detail "B".								
	11-Open ground wire hole .297" section E-E								
	12- Section G-G holes must be laid out manually, open to #30.								
	13-Deburr holes.								

11-10-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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October 13, 2011 1:04:52 PM

74933

Page 3

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Setup Start *NS1*

Stop *NS2*

1

Cust Item ID:

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170	Skidtubes								
Skidtubes									
Skidtubes									
	Memo	0.00							
	1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507. and Detail "F"								
	2-Counter Sink X-BOLT holes as per Dwg D3507								
	3-Deburr and blow out chips from inside of tube.								
	4-Bond web as per Dwg D3507 & QSI 015								
	A/R 241 Sike Flex Batch: <u>m118393</u>								
	Exp Date: <u>12-05-05</u>								
	start time: <u>2:30</u>								
	end time: <u>11/10/20 8:30</u>								
	5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.								
	A/R AL ROD Batch: <u>m117884</u>								
	6-Grind welds flush								
	7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B								
	8-Deburr Rivet holes.								

DP 11-10-19

BE 11/10/20

DP 11-10-20

Dart Aerospace Ltd

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Page 5

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC10- Inspect visual per QS1004- ground welds Memo	0.00 0.00							
190 *190* Skidtubes Skidtubes	Skidtubes Memo 1-Rivet D3506-1/-3 as per Dwg D3507.	0.00 0.00							
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

Dart Aerospace Ltd

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Page 6

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210 Pressure Wash per QSI005 4.3

0.00

210

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

Handwritten signature and date 10/10/24

220 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

220

Powdercoat

Powder Coating

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Handwritten notes: 10:15, 320 OF, 10:45

Handwritten signature and date 10/10/24

230 QC3- Inspect Part Finish

0.00

230

QC

Memo

0.00

Quality Control

Handwritten signature and date 10/10/24

Handwritten note: m11745

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Page 7

October 13, 2011 1:04:52 PM

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1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	HandFinishing	0.00							
260									
HandFinish	Memo	0.00							
Hand Finishing	<div>✓ 1- Install Wearplate & Ground Wire inserts as per Dwg D3507.</div> <div>✓ 1- Inspect for Foreign objects</div> <div>✓ 2- Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" A/R 241 Sika Flex Batch: <u>M118343</u> Exp Date: <u>12/03</u></div> <div>✓ 3- Install Wearplates as per Dwg D3507, Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube Do not Install Screws where indicated on Dwg (Note #6) A/R 241 Sika Flex Batch: <u>M118933</u> Exp Date: <u>12/03</u></div> <div>✓ 4- assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M110348</u></div> <div>✓ 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: <u>M118988</u></div>								

1 ~~0~~ 11 11/10/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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October 13, 2011 1:04:52 PM

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Stop *NS2*

Start Date: 10/13/11 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 10/20/11 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

270 QC5- Inspect part completeness to step on W/O

0.00

0.00

270

QC

Memo

Quality Control

280	Pick Kit	0.00
-----	----------	------

0.00

280

Packaging

Memo

0.00

Packaging

290	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

0.00

290

OC

Memo

0.00

Quality Control

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 9

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Cust Item ID:

Required Date: 10/20/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	Packaging	0.00							
300									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-751-011								
	Location: <u>301</u>								
	PPP Rev: <u>301</u>								
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.00							
Quality Control									

11/10/28

MF 11-10-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

October 13, 2011 1:05:06 PM

Page 1

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74933

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/20/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A06-06-21New Issue JLM
 IPP Rev:B 06-12-18 As per Rev B JLM
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC vcerified DD
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-130

Purchased

No

Each

1,099.000

38

AI S7-1032-130

Insert

**

11/10/21

Location

Loc Qty

Loc Code

ST281

922

1118966

838

118966

922

ST282

177

117717

31

118386

146

D3507-1-BENT

Manufactured

No

120

Each

3.0000

1

1

D3507-1-BENT

Skidtube Assembly EC135

**

Location

Loc Qty

Loc Code

LG

3

71201

1

72564

2

11-10-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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October 13, 2011 1:05:06 PM

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/20/11

Start Qty: 1.00

Required Qty: 1.00

D3504-1 Manufactured No

170 Each 13.0000 2 2

D3504-1

Crossbolt Spacer

**

BE 11/10/20

Location Loc Qty Loc Code

LG 11

71130 11

LG001 2

53742 2

D3504-3 Manufactured No

170 Each 17.0000 1 1

D3504-3

Crossbolt Spacer

**

BE 11/10/20

Location Loc Qty Loc Code

LG001 17

53743 17

D3504-5 Manufactured No

170 Each 11.0000 2 2

D3504-5

Crossbolt Spacer

**

BE 11/10/20

Location Loc Qty Loc Code

LG 11

71226 11

D3505-1 Manufactured No

170 Each 0.0000 1 1

D3505-1

Web

375211

**

SAD 11-10-18

D3506-1 Manufactured No

190 Each 11.0000 4

D3506-1

Doubler

**

4 11/10/21

Location Loc Qty Loc Code

ST063 11

51789 11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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October 13, 2011 1:05:06 PM

Page 3

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D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/20/11

Start Qty: 1.00

Required Qty: 1.00

D3506-3 Manufactured No

190

Each

69.0000

2

D3506-3

Doubler

**

2

11/10/21

Location

Loc Qty

Loc Code

ST063

69

51790

69

MS20601-AD4W3 Purchased

No

190

Each

2,438.000

12

12

MS20601-AD4W3

Rivet

**

11/10/21

Location

Loc Qty

Loc Code

ST321

2438

114538

2438

ALS4-1032-225 Purchased

No

260

Each

2,660.000

1

1

ALS4-1032-225

Insert

**

11/10/21

Location

Loc Qty

Loc Code

ST282

2660

108696

808

110768

62

118386

860

118966

930

X1

Dart Aerospace Ltd

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Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/20/11

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

260

Each

1,987.000

31

31

AN3C4A

BOLT

**

11/10/24

Location

Loc Qty

Loc Code

ST350

1987

117313

2

117688

5

117872

22

118112

16

118451 *

442

118706

500

118838

1000

x 28

x 3

AN3C5A

Purchased

No

260

Each

1,350.000

2

2

AN3C5A

Bolt

**

11/10/24

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1343

116419

28

117343

144

117764

169

117872

2

118451

500

119127

500

VZ

October 13, 2011 1:05:06 PM

Shop Packet Print

Page 4

Dart Aerospace Ltd

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Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/20/11

Start Qty: 1.00

Required Qty: 1.00

AN526C1032R10

Purchased

No

260

Each

265.0000

2

2

AN526C1032R10

Screw

**

41 u/10/24

Location

Loc Qty

Loc Code

FP-B

91

108062

91

ST327

100

114494

100

ST328

74

110049

74

x2

AN960C10L

NAS1149C0332

Purchased

No

260

Each

0.0000

33

33

***AN960C10L ***

washer

D2965

Manufactured

No

260

Each

41.0000

1

1

D2965

Cap, 105 Skidtube

**

(x33) u/10/24

Location

Loc Qty

Loc Code

FP006

41

71371

41

D2965-3

Manufactured

No

260

Each

4.0000

1

1

D2965-3

Cap

**

u/10/24

Location

Loc Qty

Loc Code

FP005

4

50560

1

71300

3

x1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 13, 2011 1:05:06 PM

Work Order ID: 74933

74933

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/20/11

Start Qty: 1.00

Required Qty: 1.00

D3492-1 Manufactured No

260 Each 166.0000 4 4

D3492-1

Plug

**

ul 11/10/21

Location

Loc Qty

Loc Code

FP

166

69531

8

73402

78

74444

80

ul

D3492-3 Manufactured No

260 Each 125.0000 4 4

D3492-3

Plug

**

ul 11/10/21

Location

Loc Qty

Loc Code

FP

125

71838

45

74447

80

ul

D3492-7 Manufactured No

260 Each 14.0000 2 2

D3492-7

Plug

**

ul 11/10/21

Location

Loc Qty

Loc Code

FA-A

14

71881

14

ul

D3508-1 Manufactured No

260 Each 15.0000 1 1

D3508-1

Wearplate

**

ul 11/10/21

Location

Loc Qty

Loc Code

FP016

15

61020

3

72933

12

ul

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 13, 2011 1:05:06 PM

Page 7

Work Order ID: 74933

74933

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/20/11

Start Qty: 1.00

Required Qty: 1.00

D3508-3

Manufactured No

260

Each

6.0000

1

1

D3508-3

Wearplate

JH 10/10/2011

LocationLoc QtyLoc Code

FP021

1

38527

1

FP21

5

72169

5

VI

D3508-5

Manufactured No

260

Each

21.0000

1

1

D3508-5

Wearplate

JH 10/10/2011

LocationLoc QtyLoc Code

FP021

21

71688

9

72416

12

VI

D3508-7

Manufactured No

260

Each

8.0000

1

1

D3508-7

Wearplate

JH 10/10/2011

LocationLoc QtyLoc Code

FP020

7

72932

7

FP021

1

67739

1

VI

D3558-1

Manufactured No

260

Each

15.0000

1

1

D3558-1

Gasket

JH 10/10/2011

LocationLoc QtyLoc Code

FP014

15

50925

3

73561

12

VI

October 13, 2011 1:05:06 PM

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Page 7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 13, 2011 1:05:06 PM

Page 8

Work Order ID: 74933

74933

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/20/11

Start Qty: 1.00

Required Qty: 1.00

D3558-3

Manufactured No

260

Each

4.0000

1

1

D3558-3

Gasket

**

Jul 11/10/24

Location

Loc Qty

Loc Code

FP014

4

71651

1

72170

3

✓1

D3558-5

Manufactured No

260

Each

5.0000

1

1

D3558-5

Gasket

**

Jul 11/10/24

Location

Loc Qty

Loc Code

FP014

5

67485

5

✓1

D3558-7

Manufactured No

260

Each

5.0000

1

1

D3558-7

Gasket

**

Jul 11/10/24

Location

Loc Qty

Loc Code

FP014

5

67162

5

✓1

NAS1611-007

Purchased No

260

Each

276.0000

2

2

NAS1611-007

O-RING

**

Jul 11/10/24

Location

Loc Qty

Loc Code

FP-A

276

103697

276

✓2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 9

October 13, 2011 1:05:06 PM

Work Order ID: 74933

74933

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/20/11

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

260

Each

103.0000

4

4

NAS1611-010

O-RING

**

ul 11/10/20

LocationLoc QtyLoc Code

FP

89

117460

8

118077

1

118612

80

FP-A

14

110915

14

NAS1611-013

Purchased

No

260

Each

100.0000

4

4

NAS1611-013

O-RING

**

ul 11/10/20

LocationLoc QtyLoc Code

FP

55

117291

2

117887

53

FP-A

45

116582

5

118384

40

AN3C4A

Purchased

No

280

Each

1,987.000

8

8

AN3C4A

BOLT

**

800 - 11-10-26.

LocationLoc QtyLoc Code

ST350

1987

117313

2

117688

5

117872

22

118112

16

118451

442

118706

500

118838

1000

October 13, 2011 1:05:06 PM

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 74933

74933

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/20/11

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

NAS1149C0332
R

Purchased

No

280

Each

0.0000

8

8

***AN960C10I ***

washer

D3512-1

Manufactured

No

280

Each

12.0000

2

2

D3512-1

Wearplate

**

m 119124 sp 11-10-26

**

sp 11-10-26

Location

Loc Qty

Loc Code

ST500

12

73955

12

2a

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO ~~71784~~
74933 M.L.J

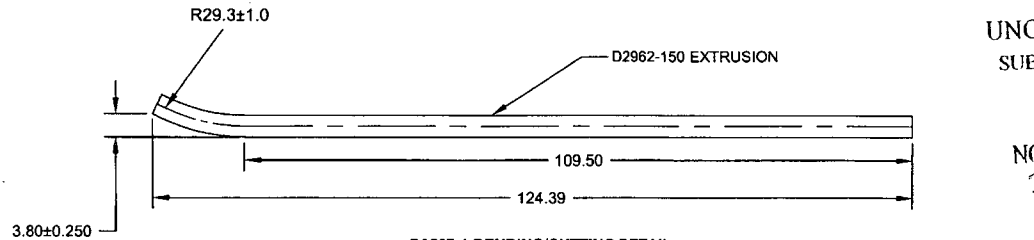
11/10/11

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20801AD4W3	RIVET

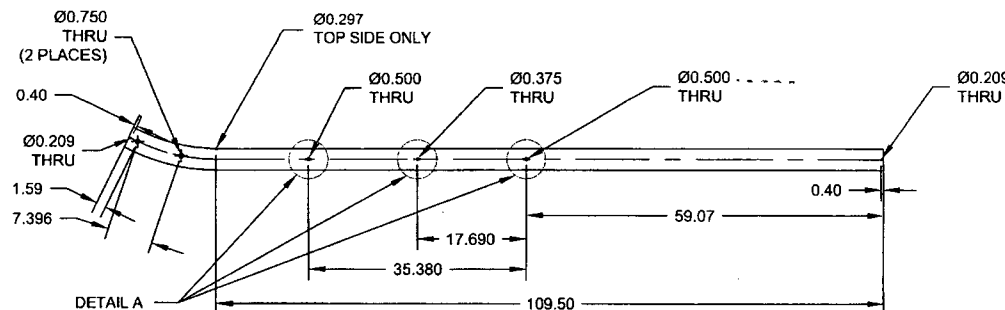
GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

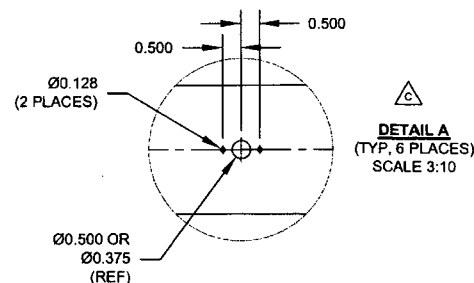
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MATL	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	<i>JC</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	D3507	SHEET 1 OF 2
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	EC 135 SKIDTUBE	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A
(TYP, 6 PLACES)
SCALE 3:10

RELEASED
07-11-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

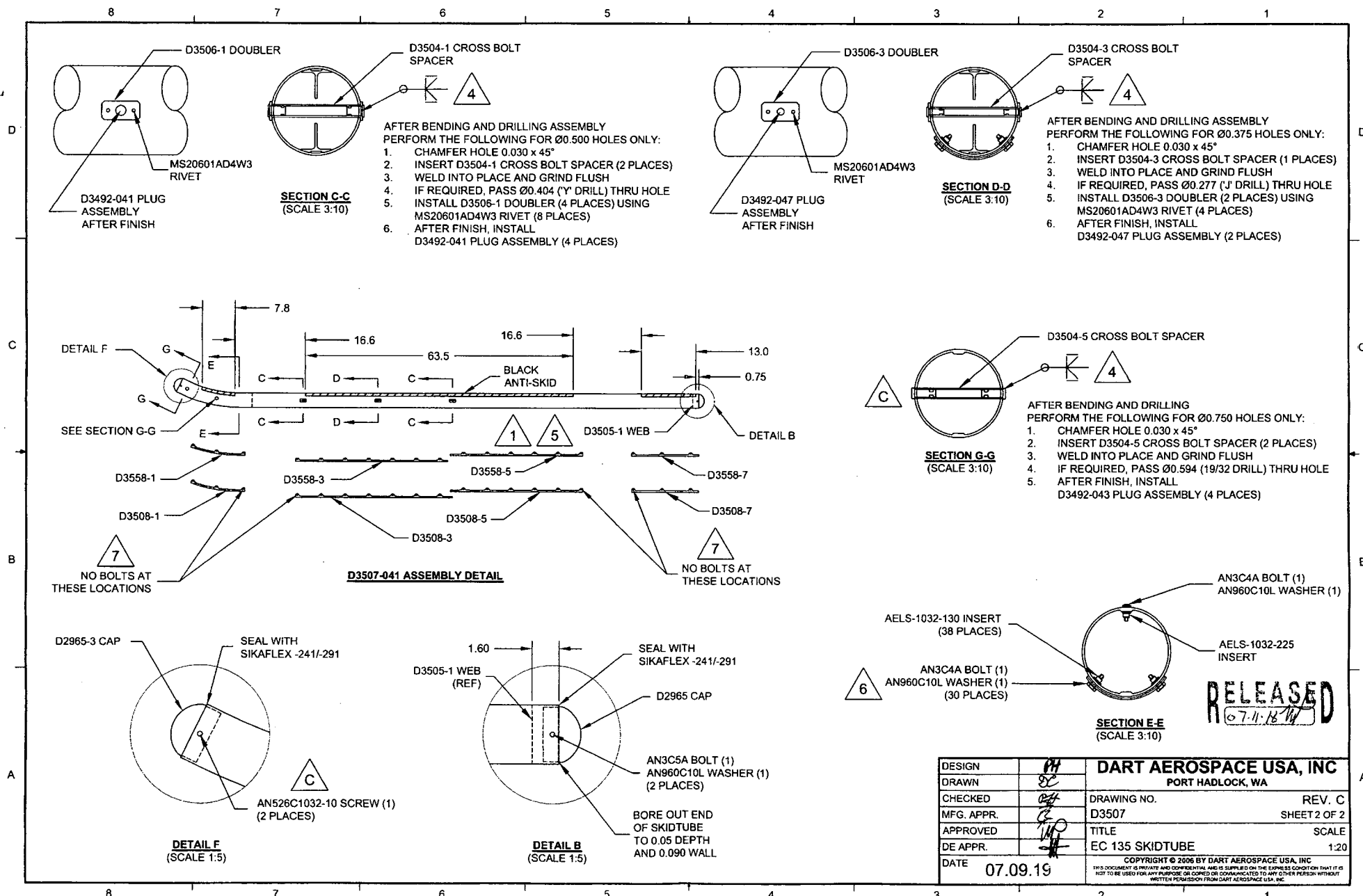
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74933

24287



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 257

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: B6666P
Part number: D135-751-011
Description: 135
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat Burns Date of Test Coupon 11-06-22

Welder Barclay Elliot Date of Test Coupon 11-06-22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld